

Date: Friday, 2/23/2007 8:33:12 AM  
 User: --Kirt Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 30906		
Estimate Number	: 11243		
P.O. Number	: N/A	Part Number	: D33795
This Issue	: 2/23/2007 S.O. No. : N/A	Drawing Number	: D3379 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 30051	Material	: N/A
	Type : PURCHASED PARTS	Due Date	: 3/20/2007
Written By	:	Qty:	8 Um: Each
Checked & Approved By	: <u>07.02.23</u>		
Comment	: Est Rev A New Issue 05-12-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010B0625X0200	1010-1025 steel bar .625 x 2.00
-----	-----------------	---------------------------------



Comment: Qty.: 0.2258 f(s)/Unit Total : 1.8060 f(s)  
 1010-1025 steel bar .625 x 2.00  
 batch: M103210 ml 070617

(8)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3379  
 Dwg Rev: C  
 Prog Rev: C

ml 070617

(8)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 070617

(8)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

J.F. 07/06/28

(8)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/06/28

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *h*   Date: 07/02/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:33:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 30906

Part Number: D33795

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

36 07-06-28

8

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

~~Receive & Inspect For Transit Damage~~  
Ensure material certification is attached

PTD

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

N/A

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 5796

16/4/29

8

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107106129

Job Completion



12 DF-0629

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-29	7/8	permanent change				u	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

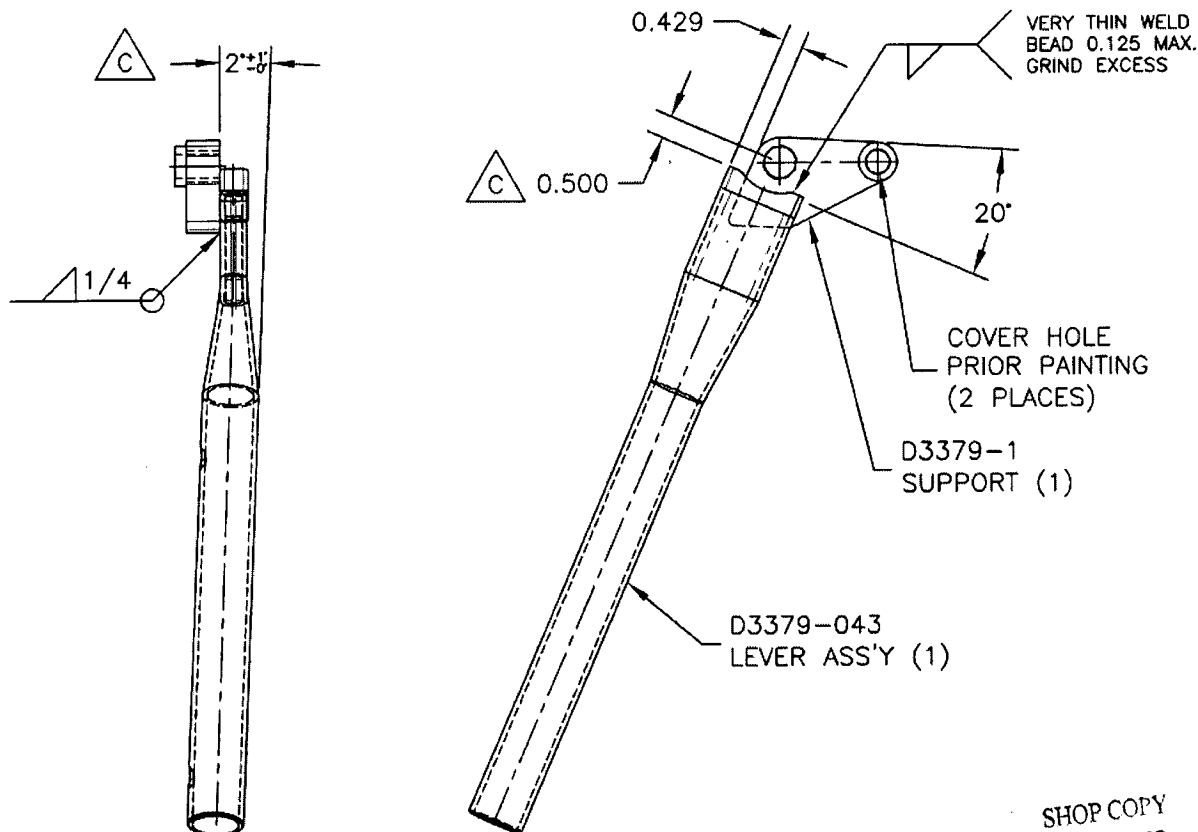
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 13	DRAWN BY JE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED [Signature]	DRAWING NO. D3379	REV. C SHEET 1 OF 4
DATE 05.05.27	TITLE ARM WELDMENT		SCALE 1:1
A	04.12.13	NEW ISSUE	
B	05.02.25	RE-DESIGN D3379-5	
C	05.05.27	2" WAS 4"; UPDATE DIMENSIONS	

RELEASED  
as/ot/06



### D3379-041 ARM WELDMENT

#### NOTES:

- 1) POSITION PARTS AS PER JIG D3379-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF 4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE  
WORK ORDER  
NO. 30906

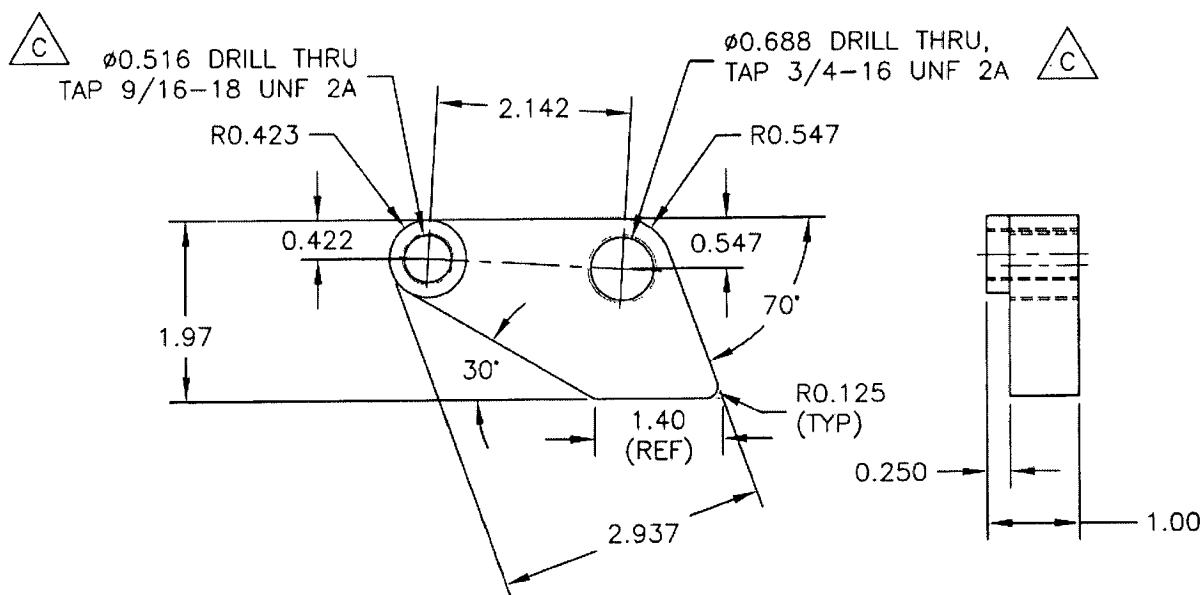
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3379	REV. C SHEET 2 OF 4
DATE 05.05.27	TITLE ARM WELDMENT		SCALE 1:2

RELEASED  
*[Signature]*  
05/07/05



### D3379-1 SUPPORT

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.000 STEEL (REF. DART SPEC. M1010-B1.000x02.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 30906

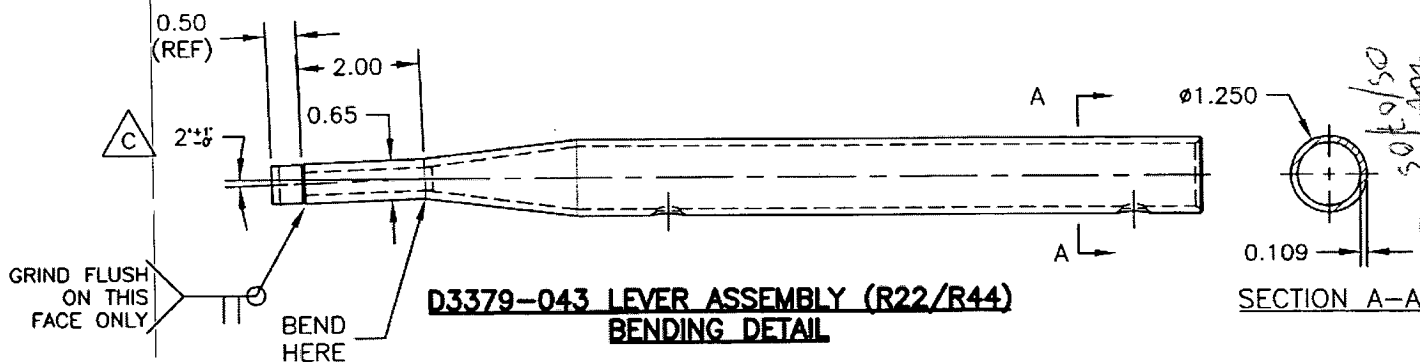
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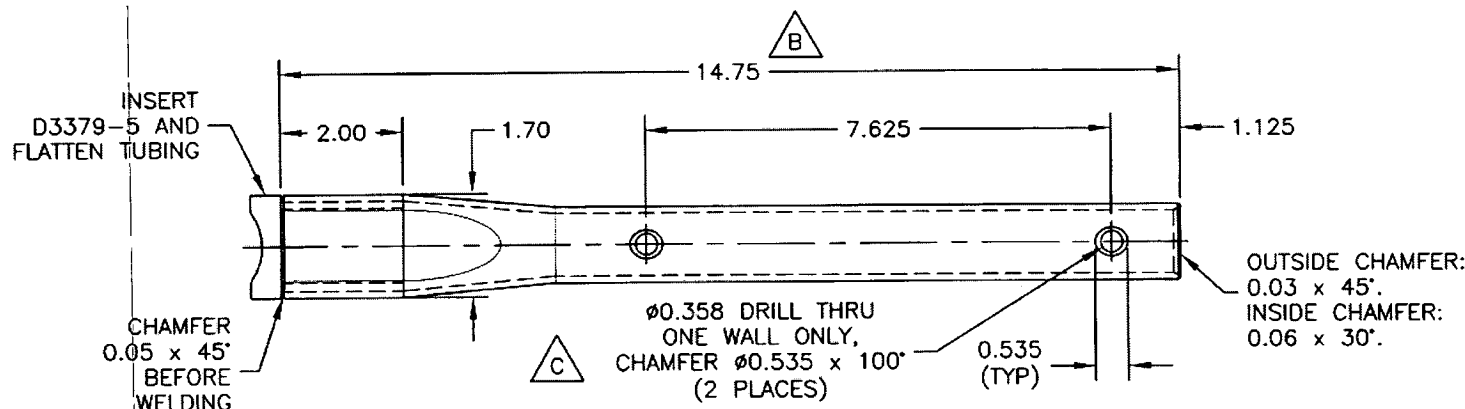
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	D3379	SHEET 3 OF 4
05.05.27	TITLE	ARM WELDMENT	SCALE
			1:3

RELEASED



**D3379-043 LEVER ASSEMBLY (R22/R44)**  
**BENDING DETAIL**



**D3379-3 LEVER (R22/R44)**

**NOTES:**

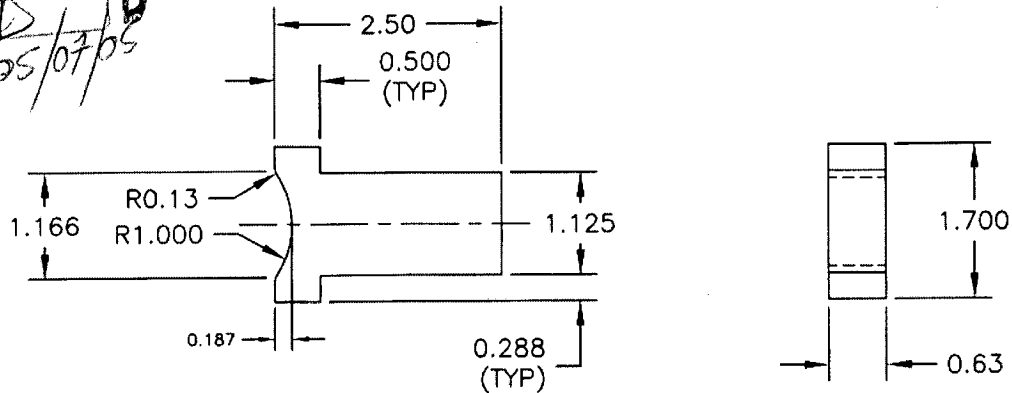
- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.250W.109)
- 2) WELD PER QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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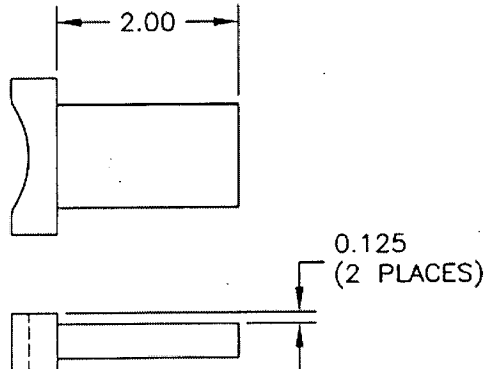
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3379	REV. C SHEET 4 OF 4
DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:1

RELEASED  
*[Signature]*  
05/07/05



**D3379-5 LASER CUT PATTERN (R22/R44)**



**D3379-5 PLATE (R22/R44)**

**NOTES:**

- 1) MATERIAL: 1010-1025 BAR MILD STEEL, 0.625 THICK  
(REF. DART SPEC. M1010-B0.625)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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